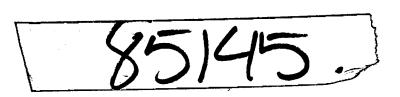
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June-04-12 1:27:46 PM

DC

Document Control

Item ID: D350-636-013 \*N900040100\* **Revision ID:** Skidtube LH Item Name: **Start Date:** 04/06/2012 Start Qty: 1.00 Cust Item ID: **Required Date:** 18/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: MLJ Date: 12 06 0 **Tooling:** Approvals: Date: SPC (Y/N): Date: Date: Operation Sequence ID/ Set Up/ Tool ID . Tool # Plan Reject Accept Reject Insp. Work Center ID Description Qty Qty Number Stamp **Run Hours** Code Draw Nbr **Revision Nbr** D2750 · D3492 4 1 IIN-D350-636 100 0.00 DOCUMENT CONTROL \*100\*



Photocopy blue file and type labels per PPP D350-636

Memo

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Dart Ae	rospace	Ltd					. 4	• <b>5</b> - 1
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Item ID: Revision ID:	D350-636-0	13				Accept	*N900	0040	100	)*	Setup Sta	art *N
Item Name:	Skidtube LH										St	op *N
Start Date: Required Date:	04/06/2012	Start Qt Req'd Q	-	_	1* 1*		Cust Item Customer:					
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Sequence ID/ Work Center II	D	Operatio Descripti				Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number
Skidtubes Skidtubes			Memo 1- Pick D20	600-3 Bent	BK	12/06/2 &				_ · _ · _ · _ · · - · · · · · · · · · ·		
				FWD and AFT ender dwg D2750	ls, remove	bending marks. Scribe batch	h# inside <i>BE</i>	12/06	38			
·			3- Drill pilo deburr.	ot holes for blade t	fitting bolt	holes using DT8983. Open	to 0.500", 7	AD 12.	06. T	,		
			4- Locate D	OT8330 off of blac	de fitting bo	olt holes and drill pilot holes	J					
			5- Drill onl	y two fwd step ho	les using D	T9616. Ensure proper posit	ioning. BE	12/06/2	8			
						neet 4 (D2750-3 details).Dri nly DT8863B for second sid	ill using drill	)				
		,		DT8863B on secon ID SIDE***	nd side of t	ube and drill pilot holes for	detail B.	SAD	12 6	x6-28		
			fitting locat	tion holes to 0.500	" (total of	V to 0.375" (2 holes per sid 4 holes per side) as per dwg ail T to 0.500" (8 holes per	D2750.	)				

0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

Dart Aerospace Ltd	Dart	<b>Aeros</b>	pace	Ltd
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W/O:		WORK ORDER CHANGES												
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Quality Control

\*85145\*

Page 3

Item ID: D350-636-013 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Skidtube LH **Start Date:** 04/06/2012 Start Oty: 1.00 **Cust Item ID: Required Date:** 18/06/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Qty Qty Number Stamp **Run Hours** Code 11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left, from bending as per QSI 004
A/R Aluminum Rod batch: m/22/30 12-Grind welds flush as per Dwg D2750 120 QC10- Inspect visual per QSI004- ground welds \*120\* QC Memo Quality Control QC5- Inspect part completeness to step on W/O 130 \*130\* QC 0.00 Memo

Dart Aerospace Ltd	Dart	<b>Aeros</b>	pace	Ltd
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Page 4

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Item ID: Revision ID:

D350-636-013

Accept

\*N900040100\*

Setup Start

Item Name: Start Date:

04/06/2012

Skidtube LH

Start Otv: 1.00 **Reg'd Oty:** 1.00

Cust Item ID:

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

Date:

Run

**Required Date:** 18/06/2012

Date:\_\_\_\_

SPC (Y/N):

Date:

Sequence ID/ Work Center ID Operation Description

Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Qty

Reject Otv

Reject Insp.

Number Stamp

140 \*140\*

HandFinish

Memo

Chemical Conversion Coat per QSI005 4.1

0.00 0.00

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

\*150\*

QC Quality Control

Memo

0.00

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Item ID: Revision ID:	D350-636-01	3				Accept	*N90	0040	100	<b>)</b> * s	Setup	Start	ıv	S1*
Item Name:	Skidtube LH											жор	^N	S <sub>2</sub> ^
Start Date:	04/06/2012	Start Qt	-	7	*1*		Cust Ite							
Required Date:	18/06/2012	Req'd Q	ety: 1.00	7	*1*		Custome	er:						
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Approvals:	Process Pla	n:		Date:		Tooling:		Date:		Г	<b>X</b> uii		1/1	R1*
	QC:		·	Date:		SPC (Y/N):		Date:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operatio Descripti				Set Up/ Run Hours	Tool H	D Tool #	Plan Code	Accept Qty	Rej Qty	ject y	Reject Number	Insp. Stamp
160		Skidtubes				0.00								
*160* Skidtubes			Memo			0.00								
Skidtubes			1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750  3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750.									•		
	,										1.		·	
			4-Chamfer h instructions	holes of section AW-AW, AV-AV, T and ground handling. (welding on sheet 10)								106	-	
				d blow out all c ine as required.	•	inside of tube. Prepare tube	e for welding,							
				D2739 in place flex-291	batch: 7	1015 1121 407 date: \$7 13-04-1	2 5	SAD	12-0	7-08				
		7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QS1004 (welding instructions on sheet 10)  A/R Aluminum Rod batch: M22130 BE 12679												
		8-Grind welds flush as per Dwg D2750								1				
			9-Spot face g	ground handlin	ng holes (to	tal of 4 places per side) as	per dwg D2750	SBEI	ap 7	14				
			10-Deburr ho	oles				5						

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W/O:			W	ORK ORDER CH	ANGES					<b>4</b>
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Item ID:

D350-636-013

Accept

\*N900040100\*

Setup Start

**Revision ID:** Item Name:

**Start Date:** 

Skidtube LH

04/06/2012

Start Qty: 1.00

Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Required Date:** 18/06/2012

Process Plan:

Date:

Tooling:

Date:

Run

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 170

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ **Run Hours** 

Tool # Plan

Code

Accept Qty

Reject Reject Qty Number Stamp

Insp.

\*170\*

Memo

0.00

Quality Control

\*120\*

180

Quality Control

QC5- Inspect part completeness to step on W/O

190

Pressure Wash per QSI005 4.3

Memo

0.00

\*190\*

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:	Approval QC Inspector
Resolution:	
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Resolution:	
Resolution:	
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QC5- Inspect part completeness to step on W/O

Memo

240

Quality Control

W/O:			V	ORK ORDER CHAP	IGES		-		<b>~</b>
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Work Ord		145		*85	145*						Page 9
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube LH	13		Accept	*N9000	<b>040</b>	100	<b>*</b> S	etup Start Stop	IV	S1*
Start Date: Required Date Reference:	04/06/2012 e: 18/06/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	<b>D</b> :				1.4	
Approvals:	Process Pla	in:	Date:	Tooling:	Dat	te:	-	R	un Start	"I <b>V</b>	R1*
	QC:		Date:	SPC (Y/N):	Dat	te:			Stop	*N	R2*
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 <b>*250*</b> Packaging		Pick Kit  Memo		0.00				S	573	- 12/7	126

260

QC4- 100% Inspect kits for completeness

\*260\*

Quality Control

Packaging

Memo

0.00 PAS 17647

270

\*270\* Packaging

Packaging

Packaging

Memo

Package as per PPP D350-636-013

0.00

0.00

1012/1/200

W/O:		^	W	ORK ORDER CHANG	ES			•
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Work Order I	ID 8	85145	,
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QC

Quality Control

\*85145\*

Page 10

June-04-12 1:27:46 PM D350-636-013 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Skidtube LH **Start Date:** 04/06/2012 Start Qty: 1.00 **Cust Item ID: Required Date: 18/06/2012** Req'd Qty: 1.00 **Customer:** Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Tool ID Tool # Sequence ID/ Operation Set Up/ Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 280 QC21- Final Inspection - Work Order Release 0.00 \*280\*

0.00

Memo

N10727

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### **Picklist Print**

June-04-12 1:27:50 PM

Work Order ID: 85145

Parent Item Name: Skidtube LH

\*85145\*

Parent Item:

D350-636-013

\*D350-636-013\*

**Start Date:** 04/06/2012

Required Date: 18/06/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:H02.09.25Rearranged procedure steps KJ

IPP rev I 06.03.30 Per rev. D dwg

EC

IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec 10.06.22 revise seq110 DD verf:EC

IPP Rev:M 10.10.01 as

	per IIN revH DD v		D.	n :	····		T1 '4 C						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	29.0000	1	1			
*D2600-3-	-RFNT*								**		B 8	26330	EN/06
				Location	l	Loc (	<u>Qty</u>	Loc Code					~/
				LG			29				_		
					66875		7				_		
					73253		1		_		_		
					75021		1				_		
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					81330		4				_		
					83305		1		<u> </u>	·			
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D3493-1		Manufactured	No			110	Each	127.0000	2	2		~	
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Loc Code Location Loc Qty ST050 127 77573 1 82023 26 83097 100

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# **Picklist Print**

Page 2

June-04-12 1:27:50 PM

Work Order ID: 85145

Parent Item:

D350-636-013

Parent Item Name: Skidtube LH

\*85145\* \*D350-636-013\*

Location

**Start Date:** 04/06/2012

**Required Date: 18/06/2012** 

Start Qty: 1.00

Required Qty: 1.00

D2739

D2744

\*D2739\*

350 I Beam

Manufactured

Manufactured

No

160

Each

Loc Qty

13.0000

Loc Code

SAD 12-07-03

LG 13 72155 81508 83447 83448 5 2 83548 Manufactured 160 Each

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BE 12/06/28

\*D2744\* Cap

D3490-1

\*D3490-1\* Cross Bolt Spacer

Location Loc Qty LG002 35 62715 3 78900 31 83412 160

Each

45.0000

Loc Code

Loc Code

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Location Loc Oty LG 2 81976 LG001 43 62450 2 74875 77042 3 83269 34

W/O:			W	ORK ORDER CHANG	iES .				•
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NCR:		V	WORK OR	DER NON-CONFORM	ANCE (NCI	₹)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	sign Sign	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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### **Picklist Print**

June-04-12 1:27:50 PM

Work Order ID: 85145

Parent Item:

D350-636-013

Parent Item Name: Skidtube LH

\*85145\*

\*D350-636-013\*

**Start Date:** 04/06/2012

**Required Date:** 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-5

D2743

Crossbolt Spacer

Cross Bolt Spacer

Manufactured

Manufactured

160

Each

57.0000

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Page 3

Location Loc Qty Loc Code LG 13 78958 13 LG001 44 83373 44 220 No Each 296.0000

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Location Loc Qty Loc Code LG 222 81965 55 83262 167 LG001 74 67766 4 68251 3 73403 64 74445 79517 2

Dart Aerospace	<b>Ltd</b>
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June-04-12 1:27:50 PM

Work Order ID: 85145

D350-636-013

Parent Item Name: Skidtube LH

\*85145\* \*D350-636-013\*

**Start Date:** 04/06/2012

**Required Date:** 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Parent Item:

Purchased

No

230

Each

781.0000

\*\*

\*ALS4-1032-225\*

<b>Location</b>	Lo	oc Qty	Loc Code			
ST281		758				
108696		146				
110768		62	M1222	C. C.		
118386		55	1711000	OP	1	2 8
118966		68			^ `	<b>3</b>
121269		427				
ST282		23	•			
120410		10				
120451		13				
	230	Each	1,302.000	34	34	_

AN3C5A

Purchased

No

34 Ml 1107/23

\*AN3C5A\*

<u>Location</u>	Loc Qty	Loc Code	
FP001	7		
115835	7		
ST350	1295		
116419	28		
117343	13		
117764	7		
117872	2		
119749	23		
120423	28		
121068	12		
121255	500		<u> </u>
121444	182		
121708	500		

Dart Aerospace Ltd	Dart	<b>Aeros</b>	pace	Ltd
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W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	CEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	,												
Part No	:	PAR #:	Fault Ca	ult Category: NCR: Yes No			o DQA:	Date:					
	R	esolution:	Disposit	ion:	_ QA: N	I/C Clos	sed:	Date: _					
NCR:		V	WORK OR	DER NON-CONFORMA	ANCE (	NCR)							
DATE	STEP	Description of NC , Section A	Initial Action Description		ion B	Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspector				
,_,_			Chief Eng	Chief Eng		Date							
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Picklist Print June-04-12 1:27:50 PM					· ·	·			Page 5
Work Order ID: 85145  Parent Item: D350-636-013			5145* 350-636-0	13*					
Parent Item Name: Skidtube LH							art Date: 0 tart Qty: 1		Required Date: 18/06/2012 Required Qty: 1.00
*AN3C6A *AN3C6A*	Purchased	No		230	Each	451.0000	4 **	4 )3 l	12/07/23
			Location	L	oc Qtv	Loc Code			
			FP001		1				
			111982		1				_
			ST351		450				_
			111982		2				_
			116419		23				_
			116549		2				_
			116704		12				-
			117619		10				_
			117688		l -			-	_
			117872		5				_
			118422 119449		13 21				_
			120423		3				_
			120693		158				_
			121682		200			XLI	_
AN6C44A	Purchased	No	. <del></del>	230	Each	86.0000	4	4	<del>_</del>
*AN6C44A*							**	پايل	( ulo7/27
			Location	ī	oc Otv	Loc Code			

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	<b>\</b> :	_ Date: _				
	R	esolution:	Dispositi	on:	QA: N/C C	losed:		Date: _				
NCR:		\	WORK ORE	DER NON-CONFORMA	NCE (NCF	<del>3</del> )						
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign (	Verific		Approval	Approval			
		Section A	Chief Eng	Chief Eng	Date		on C	Chief Eng	QC Inspector			
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\*85145\* Work Order ID: 85145

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

\*D350-636-013\*

**Start Date:** 04/06/2012

**Required Date: 18/06/2012** 

Page 6

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

68.0000

M 1107/27

\*AN8C35A\*

Location	1	<u>L</u>	oc Qty	Loc Code		
FP002			67			
	115960		1			
	118286		16			
	121275		50			
ST346			1			
	114442		0			
	115188		0			-
	115960		1			
		230	Each	0.0000	38	38

AN960C10L

Purchased

No

1/1/22063\*\* (x38) Al 1/02/23.

washer

D2745

Manufactured No 230

Each

\*D2745\*

Bushing

<u>Location</u>	Loc Qty
FP	6
79518	6
FP001	116
69529	1
76142	1
83260	114

Loc Code B85414

June-04-12 1:27:50 PM

**Shop Packet Print** 

Page 6

	<del></del>							
W/O:			WC	RK ORDER CHANG	ES		•	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		,						
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes N	lo DQA:	Date: _	
	R	esolution:	Dispositio	າ:	_ QA: N/C Clo	sed:	Date: _	
NCR:		\	WORK ORDI	ER NON-CONFORM <i>A</i>	ANCE (NCR)			
DATE	STEP	Description of NC	Description of NC Corrective Action			Verification	Approvai	Approval
	SIEP	Section A ,	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		•						
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#### **Picklist Print**

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Work Order ID: 85145

Parent Item:

D350-636-013

Parent Item Name: Skidtube LH

\*85145\* \*D350-636-013\*

61689

82271

**Start Date:** 04/06/2012

**Required Date:** 18/06/2012

Page 7

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Blade Fitting Assembly, LH

Manufactured

Manufactured

Manufactured

Location

FP002

230

Each

8

Each

9.0000

Loc Code

1385867

\*\*

Il 18/02/23

D3492-1

\*D3492-1\*

Plug

No

No

230 Each

Loc Qty

257.0000

8

\*\*

Location Loc Qty Loc Code FP002 242 69531 8 74444 2 76235 83259 228 FP-A 15 83098 15

230

161.0000 \*\*

\*D3492-5\*

D3492-5

Location Loc Qty fpa 161 60 83100 83530 101

Loc Code

N/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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			,-									
Part No	;	PAR #:			NCR: Yes	No DQA	\:	_ Date: _				
	R	esolution:	Disposit	QA: N/C CI	osed:	Date: _						
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCF	1)						
DATE STEP		Description of NC	Initial	Corrective Action Section Action Description	on B Sign 8	Verifica		Approval	Approval			
		Section A	Chief Eng	Chief Eng	Date	Section	on C	Chief Eng	QC Inspector			
-												
<b>17</b> 1												

Picklist Print June-04-12 1:27:50 PM									Page 8	
Work Order ID: 85145		*Q	5145*		· · ·					
Parent Item: D350-636-013 Parent Item Name: Skidtube LH			*D350-636-013*				tart Date: 0		Required Date: 18/06/2012 Required Qty: 1.00	
D3535-25 *D3535-25* Wearshoe	Manufactured	No		230	Each	34.0000	1 **	1	Bl. 12.7-25	
·			Location FP001 62233 81357 82156 83387 83899	<u>Lo</u>	34 1 1 2 17	Loc Code			  	
D3536-25 *D3536-25* Gasket	Manufactured	No	63697 <b>V</b>	230	Each	28.0000	1 **	1	U. D-3-25,	
	·		Location FP 83391 83900	<u>Lo</u>	28 12 16	Loc Code			· - -	
D3537-1 *D3537-1* Wearpad	Manufactured	No		230	Each	83.0000	3 <b>**</b>	3	BD 12-7-25	
			Eocation FG \$5.45 \cdot .79833 FP002 69817 81360 81362 83254 83255 84091	<u>Lo</u>	10 10 73 5 14 19 1 3	Loc Code	8.0	3.		

W/O:			V	ORK ORDER CHANG	BES					•		
DATE	STEP	PROG	E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Appròval QC Inspector				
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Part No: PAF		PAR #:	Fault Ca	tegory:	NCR:	NCR: Yes No DQA:				Date:		
Resolution:			Disposit	ion:	QA: N							
NCR:		W	ORK OR	DER NON-CONFORM	ANCE (	NCR)						
DATE ST	STEP	Description of NC			tion B	Sign & Section C			Approval Chief Eng	Approval QC Inspector		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng								
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								Page 9
	*A	5145*						-
			12*					
	1 1	หายบ-ถเกต-บ	1.7					Required Date: 18/06/2012 Required Qty: 1.00
Manufactured	No		230	Each	347.0000	8	8	4.4
						**		Bl 12.7-25
		Location	<u>I</u>	oc Qty	Loc Code			
				332				_
							7	_
							<b>─</b> ð-	_
								_
Purchased	No		230	Each	774.0000	2	2	<del>_</del>
						**		SP
		<b>Location</b>	<u>1</u>	oc Qty	Loc Code			
		ST060		774				num
		54363		774			$-\lambda x$	_
Manufactured	No		230	Each	17.0000	1	1	4.4
						**		Bl 12. 9-25
		Location	<u>I</u>	oc Qty	Loc Code			
		FP002		17				_
		62239		2			<del></del>	
		83392 <b>√</b>						<del>_</del>
Manufactured	No		230	Each	28.0000	-	1	11 11 1 7 7 7 -
						**		Bl 12.7.25
		<b>Location</b>	<u>I</u>	oc Qty	Loc Code			
		FP001		28				
		82171		2				_
		83393 <b>✓</b> 83903		13 13				_
	Purchased	Manufactured No  Purchased No  Manufactured No	Manufactured No    Location   FG   81874   83588   ST072   68062   75548     Purchased No   Location   ST060   54363     Manufactured No   Location   FP002   62239   83392	*D350-636-013*  Manufactured No 230  Location FG 81874 83588  ST072 68062 75548  Purchased No 230  Location ST060  ST060  Manufactured No 230  Location S4363  Manufactured No 230  Location S4363  Manufactured No 230  Location FP002 62239 83392  Manufactured No 230	*D350-636-013*  Manufactured No 230 Each    Location   Loc Oty     FG   332     81874   2     83588   330     ST072   15     68062   2     75548   13     Purchased No 230 Each    Location   ST060   774     54363   774     Manufactured No 230 Each    Location   Loc Oty     FP002   17     62239   2     83392   15     Manufactured No 230 Each    Location   Loc Oty     FP001   28     82171   28     83393   13	*D350-636-013*  St St  St  Manufactured No 230 Each 347,0000    Loc Otv   Loc Code     FG   332       81874   2       83588   330       ST072   15       68062   2       75548   13       Purchased No 230 Each 774,0000    Loc Otv   Loc Code     ST060   774       Manufactured No 230 Each 17,0000    Loc Otv   Loc Code     FP002   17       62239   2       83392   15       Manufactured No 230 Each 28,0000	*D350-636-013*    Start Date:   Start Qty:	*D3.50-63.6-013*  Start Date: 04/06/2012 Start Qty: 1.00  Manufactured No 230 Each 347.0000 8 8  ***    Location   Loc Otv   Loc Code     FG   332       81874   2     83588   330       57072   15     68062   2     75548   13     Purchased No 230 Each 774.0000 2 2     ***    Location   Loc Otv   Loc Code     ST060   774       S4363   774       Manufactured No 230 Each 17.0000 1 1     ***    Location   Loc Otv   Loc Code     FP002   17     62239   2     83392   15       Manufactured No 230 Each 28.0000 1 1     ***    Location   Loc Otv   Loc Code     FP001   28     82171   28     82171   2     83393   13       Loc Code       Loc Code

W/O:		WORK ORDER CHANGES								•
DATE	STEP	PRO	CEDURE CH	IANGE	В	у	Date (	Qty	Approval Chief Eng /	Approval QC Inspector
									Prod Mgr	
									***	
			· ===							
Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQA:		_ Date: _	
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NCR:		V	VORK OR	DER NON-CONFORI	MANCE (I	NCR)				
DATE	STEP	Description of NC	L		ection B		Verificat	ion	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	С	Chief Eng	QC Inspector
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Work Order ID: 85145

Parent Item:

D350-636-013

Parent Item Name: Skidtube LH

\*85145\* \*D350-636-013\*

**Start Date:** 04/06/2012

**Required Date:** 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

\*D3793-3\*

Wearshoe

Manufactured

No

230

Each

28.0000

Loc Code

\*\*

BD 12.7-25.

D3794-1

\*D3794-1\*

Gasket

D3794-3

Gasket

FP001

Location

Manufactured No

Manufactured

83901

83394

230

Loc Qty

28

16

12

Each

26.0000

\*\*

BR 12.7-25

Loc Code Location Loc Qty FP 82167 6 FP002 20 83395 20 230 Each

23.0000 \*\*

BD12-7-25

Location Loc Qty FP 21 83396 21 FP002 2 74530

Loc Code

W/O:			W	ORK ORDER CHANG	GES				(1)
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Mgr	· · · · · · · · · · · · · · · · · · ·
					,				
Part No	÷	PAR #:	Fault Cat	tegory:	NCR: Ye	s No <b>D</b> (	QA:	Date: _	
		esolution:							
NCR:		V	VORK ORI	DER NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC			tion B	Veri	ication	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig: Da	1&r∣ <sub>Se</sub>	ction C	Chief Eng	QC Inspector
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			·						

June-04-12 1:27:50 PM								Page 11
Work Order ID: 85145  Parent Item: D350-636-013			5145* 350-636-0	13*				
Parent Item Name: Skidtube LH						t Date: 04/ rt Qty: 1.0		Required Date: 18/06/2012 Required Qty: 1.00
*M\$21043-6*	Purchased	No		230 Each		4 <b>★★</b>	4	BR 12-7-25
			Location FG 103693 ST301 117887 118384 120308	Loc Otv 20 20 598 2 96 500	<u>Loc Code</u>	  	#	
MS21083C8 *MS21083C8* NUT	Purchased	No	120306	230 Each		- l <b>**</b>	1	BR12-7-25.
NAS1149C0832R	Downhassed	No	Location  304  121185  121349  FP002  115884  ST303  115884  118077  119309  119638  ST304  121524	Loc Qty  75 29 46 1 4 0 1 2 1 1 230 Each	<u>Loc Code</u>	- - - - - - -		
*NAS1149C0832RV  *NAS1149C0832RV  WASHER	Purchased <b>2R*</b>	INO		230 Each		** -	l 	Bl 12-7-25.
			<u>Location</u> ST297 114915 ✓	<u>Loc Oty</u> 257 257	Loc Code	<u>-</u> -		
June-04-12 1:27:50 PM			Shop Pag	cket Print				Page 11

**Picklist Print** 

W/O:	İ		W	ORK ORDER CHAN	IGES					•
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Y	es No	DQ/	<b>\</b> :	_ Date: _	
	R	esolution:	Disposit	ion:	QA: N/C	Clos	ed:	· · · · · · · · · · · · · · · · · · ·	Date: _	
NCR:			WORK OR	DER NON-CONFORM	MANCE (N	CR)				
DATE	STEP	Description of NC	to take 1		ection B	gn & Verificati			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		ate	Section	on C	Chief Eng	QC Inspector
-										

June-04-12 1:27:50 PM

Work Order ID: 85145

D350-636-013

Parent Item Name: Skidtube LH

Parent Item:

NAS1515H3L

NAS1611-005

\*85145\*

No

No

\*D350-636-013\*

Start Date: 04/06/2012

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Required Date: 18/06/2012

13012.7.25

Start Qty: 1.00

Required Qty: 1.00

\*NAS1515H3I \*

**Location** Loc Qty 40 ST277 106

230

120360

121243 121556 2

Each

89 230 Each

18

78

44

40

Loc Code

146.0000

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\*NAS1611-005\* O-RING

Purchased

Purchased

Location Loc Qty FP001 180 106099 114220 119438 121415

Loc Code

180.0000

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W/O:		<del></del>	WO	RK ORDER CHANGE	ES				•
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Re	esolution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	₹)			
		Description of NC		Corrective Action Section		Verifi	cation	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign and Date	& Sect	ion C		QC Inspector
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Picklist Print June-04-12 1:27:50 PM								Page 13
Work Order ID: 85145		*2	5145*				- · · · · ·	
Parent Item: D350-636-013 Parent Item Name: Skidtube LH			)350-636-0	13*		tart Date: ( Start Qty: 1		Required Date: 18/06/2012 Required Qty: 1.00
NAS1611-010	Purchased	No		230 Each	h 188.0000	8	8	
*NAS1611-010*						**		BD 12-7-25
			Location FP001 /33/15 ( 110915 117460 118077 118612 119438 121259 121415 121584 121723	Loc Oty 188 14 8 1 3 47 2 4 59 50	<u>Loc Code</u>		8.	- - - - -
*AN8C21A *AN8C21A*	Purchased	No		250 Eacl	h 57.0000	2 **	<sup>2</sup>	19270A 8t
D2741	Manufactured	No	Location ST343 118758 121167 121275	57 3 4 50 250 Eacl	Loc Code  1 20.0000	l		- - - -
*D2741* Blade, 350 Skidtube			<u>Location</u>	Loc Qty	Loc Code	**	B	83135 W
			ST	-10			<u> </u>	y 0 10 1 26.
			ST466	30				_
			71856 79516	1 19				_

<b>Dart</b>	Aer	ospa	ıce	Ltd
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W/O: -			W	ORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				•						
Part No	:	PAR #:	Fault Cat	tegory:	NCI	R: Yes	No DQ	\ <b>\</b> :	Date:	
			tion: Disposition:							
NCR:		V	VORK ORI	DER NON-CONFO	RMANCE	(NCF	R)			
DATE	STEP	Description of NC		Corrective Action	Section B	0:	Verific	ation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion 	Sign 8 Date	Section	on C	Chief Eng	QC Inspector
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Picklist Print  June-04-12 1:27:50 PM							Page 14
Work Order ID: 85145  Parent Item: D350-636-013  Parent Item Name: Skidtube LH		*85145* *D350-6	336-013*		Start Date: Start Qty:		Required Date: 18/06/2012 Required Qty: 1.00
MS21083C8	Purchased	No	250	Each	81.0000 2	2	122166
*MS21083C8*					**	M	12214188
		Location	<u>L</u>	oc Qty	Loc Code		
		304		75			_
			21185	29			
		12	21349	46		-	_
		FP002		1			_
		11	15884	1			_
		ST303		4			-
			15884	0			_
			18077	1			_
			19309	2			_
			19638	I			_
		ST304		l			_
		12	21524	l			

No

NAS1149D0863J Purchased
NAS1149D0863.I\*
WASHER

 Loc Oty
 Loc Code

 ST298
 251

 118078
 34

 119307
 17

 120308
 100

 121556
 100

250

Each

251.0000

Dart Aerospace	Ltd	
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W/O:			V	VORK ORDER CHANG	R CHANGES						
DATE	STEP	PRO	CEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		·									
Part No		PAR #:	Fault Ca	tegory:	_ NCR:	Yes N	o DQA		Date:		
	R	esolution:	Disposit	ion:	_ QA: I	WC Clos	osed: Date:				
NCR:		V	VORK OR	DER NON-CONFORMA	NCE	(NCR)					
DATE	DATE STEP Description of NC		Initial	on B	Sign &	Verifica		Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng		Date	Section	ı C	Chief Eng	QC Inspector	
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		,									
		· -									
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	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
	X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
		Х			D2750-042	350 SKIDTUBE ASSEMBLY, RH
			Х		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			i —	X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
	1	1	1	1	D2739	WEB
	8	8	8	8	D2743	SPACER
	1	1	1	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
	1				D2750-1	SKIDTUBE WELDMENT, LH
		1			D2750-2	SKIDTUBE WELDMENT, RH
			1	İ	D2750-3	SKIDTUBE WELDMENT, LH
				1	D2750-4	SKIDTUBE WELDMENT, RH
	1		1		D3488-041	BLADE FITTING, LH
		1		1	D3488-042	BLADE FITTING, RH
	_ 4_	4	4	4	D3490-1	SPACER
	4	4			D3490-3	SPACER
			4	4	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
	8	8		L	D3492-043	PLUG ASSEMBLY
			8	8	D3492-045	PLUG ASSEMBLY
	1	1	1	1	D3535-25	WEARSHOE
	1	1	1	1	D3536-25	GASKET
Æ	3	3	3	3	D3537-1	WEARPAD
	8	8	8	8	D3631-1	WASHER
	_1	1	1	1	D3791-1	WEARPLATE
ļ	1 ,	1	1	1	D3793-1	WEARSHOE
△'	1	1	1	1	D3793-3	WEARSHOE
Æ	1	_ 1	1	_ 1	D3794-1	GASKET
L	1	1	_1_	1	D3794-3	GASKET
A	38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
	34	34	34	34	AN3C5A	BOLT
	4	4	4	4	AN3C6A	BOLT
	4	4	4	4	AN6C44A	BOLT
	1	1	1	1_1_	AN8C35A	BOLT
A	38	38	38	38	AN960C10L	WASHER
ZES-	1	1	1	. 1	AN960C816L	WASHER
	4	4	4	4	MS21043-6	NUT
	1	1	1	1	MS21083C8	NUT
	4	4	4	4	NAS1515H3L	WASHER

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER MLJ NO. 85145 MLJ

F	INCORPORATE DSI 9413; OTY (3) DSS37-1 WAS OTY (5) (ZN C8-1); D379-1-1/3 REPLACES D3536-13/-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE OTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON. REF. NCR 08-6-1);	РН	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES: ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS151913L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21033CB	СВ	07.05.17
D	ADD HOLES AND SHACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
С	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
В	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
Α	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE

DESIGN	₽₽,	DART AEROSPACE USA, II	NC.
DRAWN	REL	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.	MC	D2750 <sub>SHE</sub>	ET 1 OF 1
APPROVED	IN	TITLE	SCALE
DE APPR.	4	350 SKIDTUBE ASSEMBLY	NTS
08.0	7.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, I THE COCUMENT IS PRINTE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CON- NOT TO BE USED FOR ANY PURPOSE OR COPIED ON COMMUNICATED TO ANY OTHER PER	OF TANT HOUSE

**GENERAL NOTES:** 

MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

FINISH:

ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS

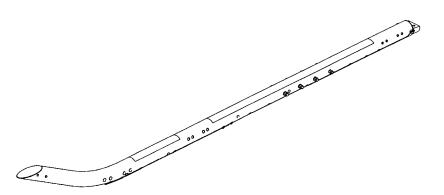
WELD PER DART QSI 004

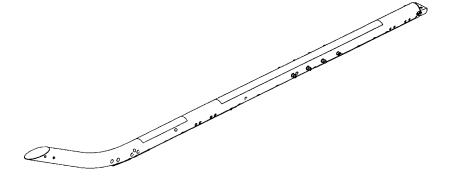
WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
WELD PER DART QSI 004
INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø 0.297) FOR WEARSHOE INSERTS
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 38 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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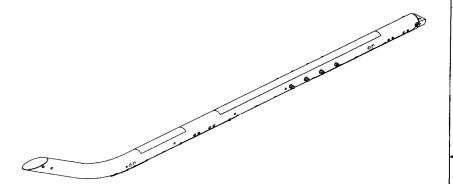
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH



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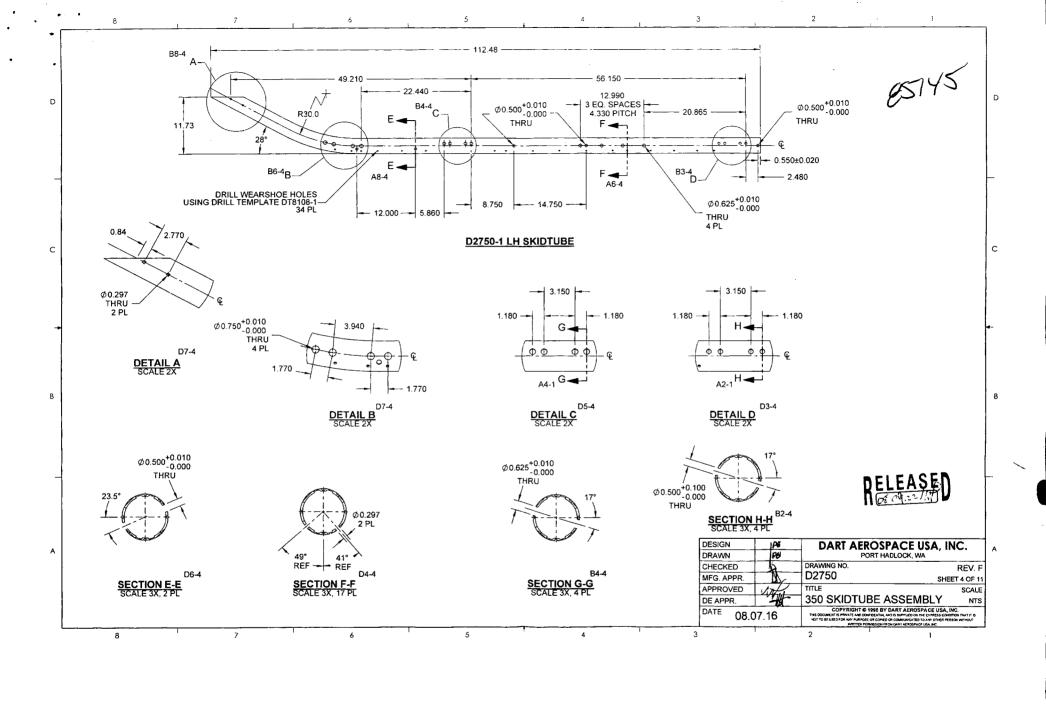
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D2750-044 350 SKIDTUBE ASSEMBLY, RH

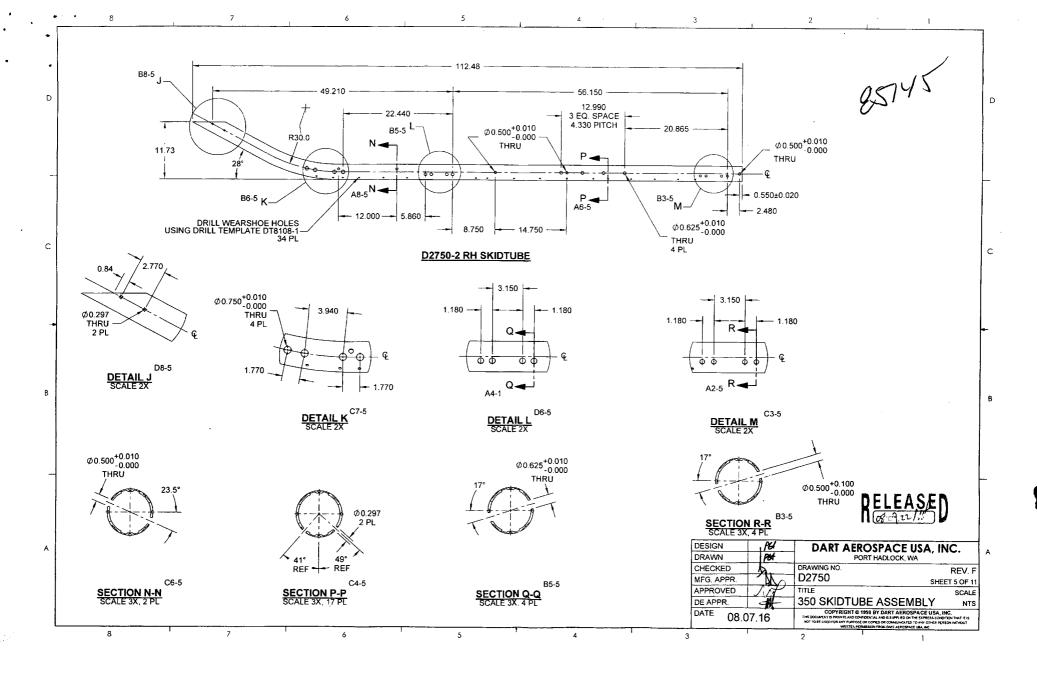
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DE APPR.	4	∃350 SKIDTUBE ASSEMBL`	Y NTS				
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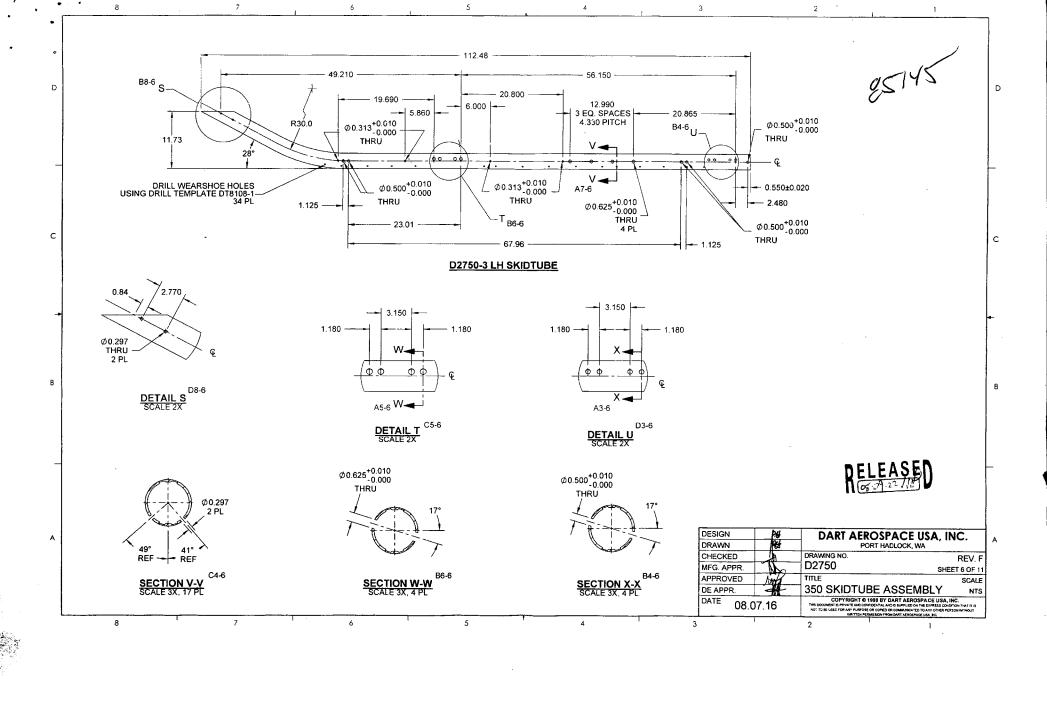
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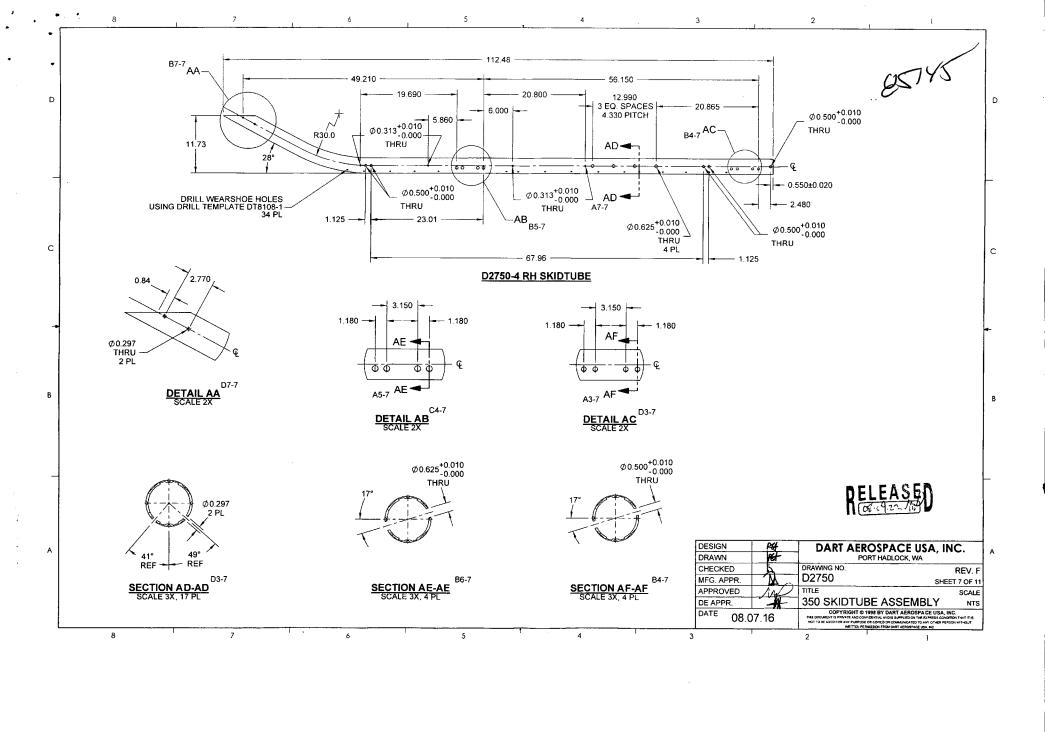


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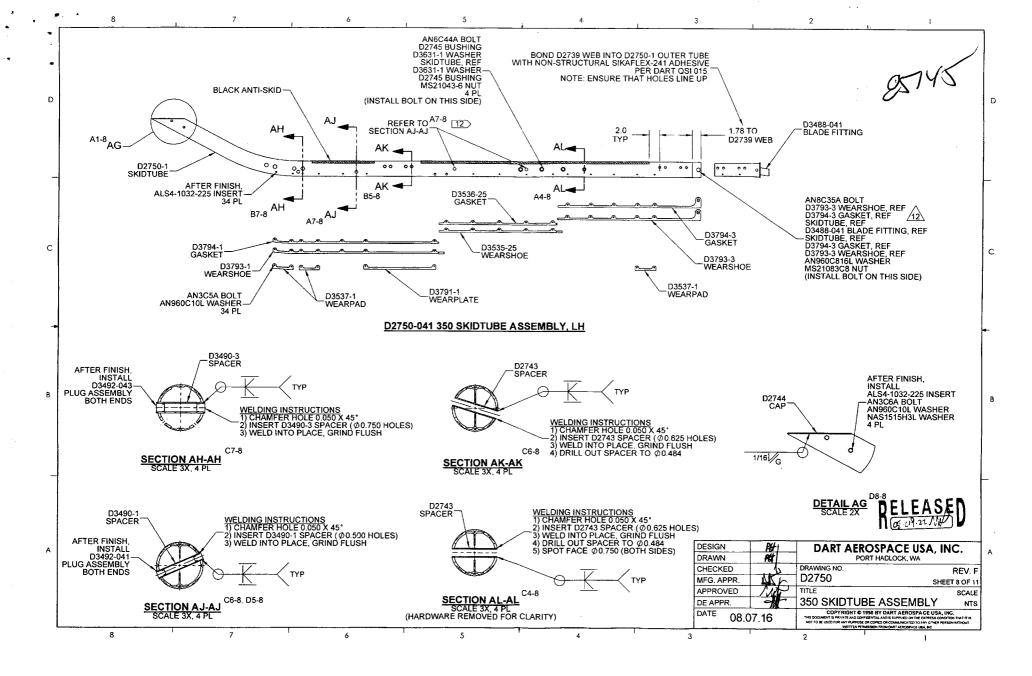


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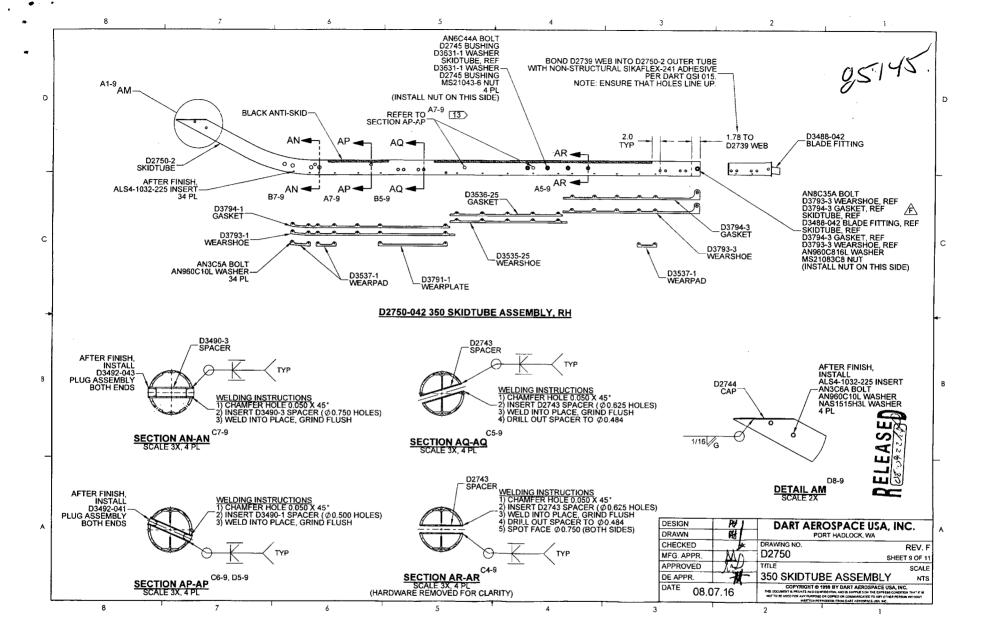
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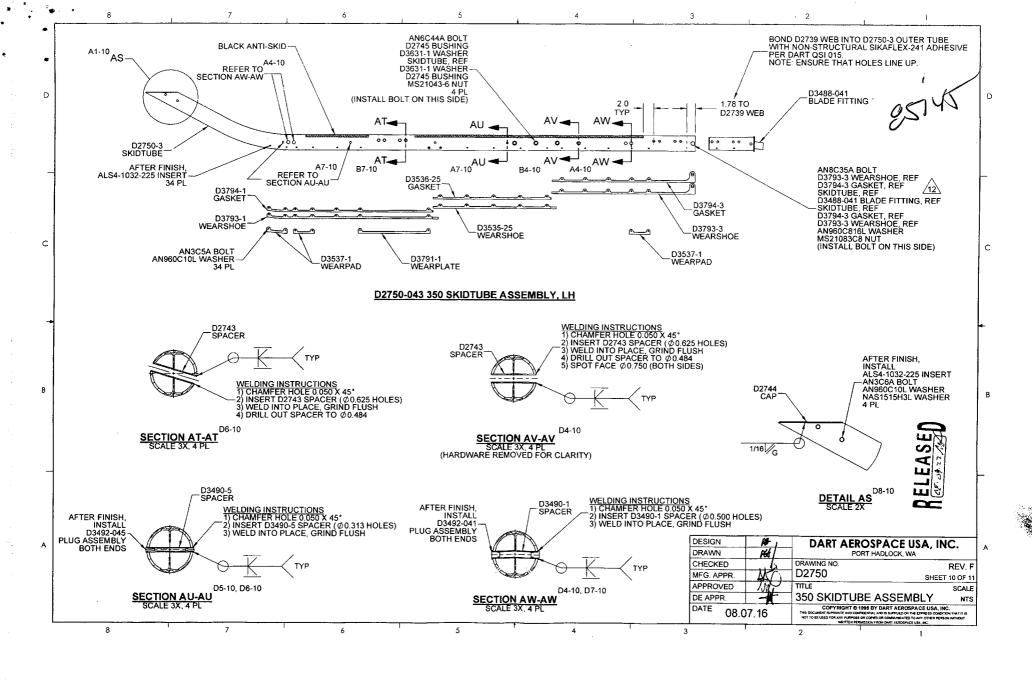
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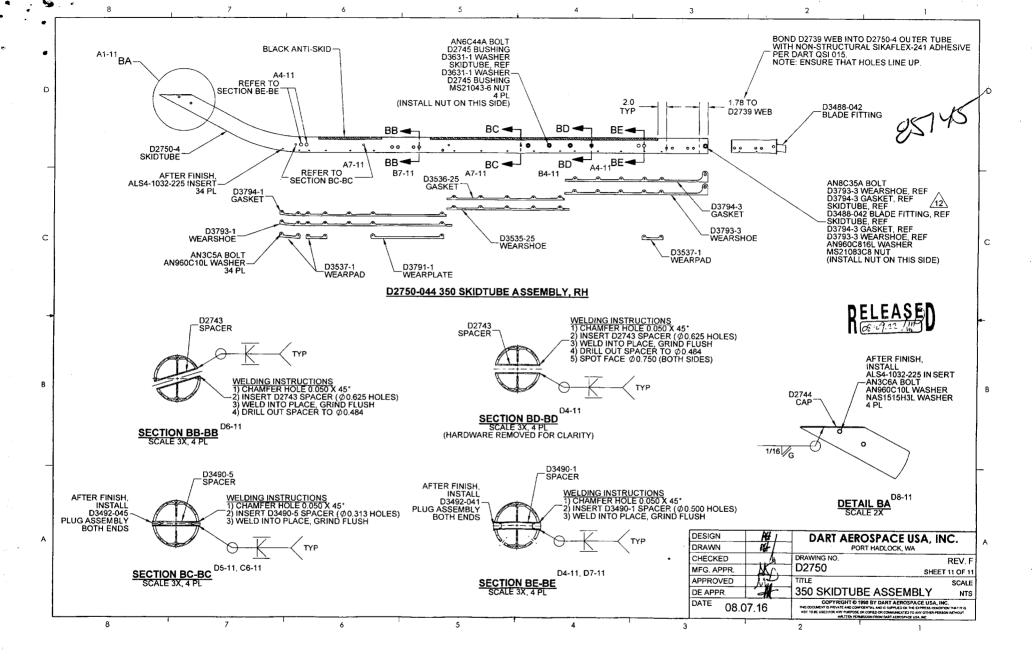


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NOTE: Date & initial all entries

NO. <u>298</u>

## AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Borcley Elliott	
Job #: 87012	
Part #: <u>\$350-636-614</u>	····
Description: Skid tube	
Welding Process: Tig Mig[]	
Base materiel: Alun hun	
Current: AC[\(\forall DC[\)]	,

#### TEST REQUIREMENTS AND RESULTS

Visual:	pass[-	fail[ ]
<b>Incomplete Penetration:</b>	pass[]	fail[ ]
Incomplete Fusion:	pass[/	fail[ ]
Cracks:	pass[]	fail[ ]
Overlap (cold lap)	pass[ ]	fail[ ]
Undercut:	pass[-]	fail[ ]
Pin holes:	pass[]	fail[ ]
Porosity (surface):	pass[ 👌	fail[ ]
Coloration:	pass[]	fail[ ]
Burn through:	pass[+	fail[]

Qualifier Date of Test Coupon 2.07.23

Welder Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld